... 5/45

145		2434
DART AEROSPACE LTD.	Work Order:	24434
Description: Saddle Fitting, Aft (Outboard/Inboard).	Part Number:	D2573/D2574
<b>Drawing:</b> D2573 Rev. D/D2574 Rev. D	Qty:	8
		Page 1 of 1

L	Step	Location	Procedure	ъβу	Date	Qty
	1	DC	Issue Traveller	<del> </del>	R (2.10)	8
ļ			Dwg not required	7 ()	05.10,12	0
	2	MV	Make from D6101-007 billet for D2573			
ı			Ensure that grain is along 7.75" length	Me	060112	
			Batch No. Nayen3	V V3	000112	
	3	MV :	Make from D6101-005 billet for D2574			
			Ensure that grain is along 5.00" length	0		6
ļ			Batch No: Bえ1801	MS	ocoloi/12	8
.	4/	MV /	Fixturing W/O No.		/N/A	
۱ļ		100	Fixturing Inspection last completed by		/ 1971	
	5	ΜӲ	Program Batch No. <u>BZ443</u> 4	M8		8
-		3.43.4	Double check by: _>		06/01/12	
	6	MV	Machine Step No 1 per Folio FA051 and inspect per attached	MS	24 12 12	8
ŀ		3.43.7	Dimension Sheets	100	06/01/12	<del>-</del>
1	7	MV	Machine Step No 2 per Folio FA051 and inspect per attached 5.9	MAO	1 . 1	(8)
ŀ	-	MV	Dimension Sheets	118	06/01/12	$\mathfrak{D}$
İ	8	IVIV	Machine Step No 3 per Folio FA051 and inspect per attached	NAO .	- 1 1	~
+	9	MV	Dimension Sheets	100	06/01/12	8
	9	101 0	Machine keyway as per dwg D2573 & D2574	MAG	06/01/16	8
ŀ	10	MV	Deburr and remove all machining marks	120	00/01/10	
	10	IVIV		56	06/01/16	8
ŀ	11	MV	Tumble for 20 minutes to remove share a dises it is 121	1	06/01/18	
>		1010	Tumble for 20 minutes to remove sharp edges #04.06.21 N/A	1 16	06/01/20	8
r	12	QC1	Inspect all dimensions to dimension sheets	. 5.0		
>	1 6	<b>Q</b> O.	inspect all dimensions to dimension sheets	5.G	06/01/19	8
	13	QC7	Second inspection			
	,0	40.		VG.	06.01.20	8
r	14	FP	Acid etch and alodine as per QSI 005 4.1			
			Troid otori dira diodirio do por doi 1000 1.1	540	06:01:51	8
亅	15	FP	Powder Coat High Gloss White (4.3.5.1) per QSI 005 4.3			
			( ( ( ( ( ( ( ( ( ( ( ( ( ( ( ( ( ( (	M	06 01 31	8
ŀ	16	QC3	Inspect Powder Coat	4.0	0, 3,	
				$(\alpha)$	06/01/31	8
	17	ST	Identify and Stock.		1	
				CX	V6/01/31	8
	18	AC		ļ		
			Cost / Part	Suc	06-02-01	8
	19	DC .	Close W/O	$\mathcal{I}$		
L			Inspection Level 21		100/02/01	L&

Rev	Date	Change	Revised By	Approved
D	99.09.09	Added inspection level, Qty column	EC	
E	00.07.04	Removed P/O for powder coat, drawing change rev. C	EC	
F	00.07.20	Removed inspection level 7	EC	1
G	01.04.27	Added D6101-007 & step 8	EC	
Н	02.10.02	Re-format; Change to Dwg Rev. D & incorporated D2574	KJ TAF	A

## **Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE	Ву	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
		* •				-		3-1

NCR:			DER NON-	CONFORMAN	ICE (NCR)		<1		
	T	Description of NC		Correctiv	re Action Section B		Verification		Approval
DATE	STEP	Section A	Initial Design Mgr	Actio	n Description Design Mgr	Sign & Date	Section C	Approval Design Mgr	Approval QC inspector
		3							
					•				
									ŧ
				**************************************					
		1		;					
	-								,

Part No:	PAR #:	Fault Category: N	ICR:	Yes (No) DQA:	Date: <u>06/02/0/</u>
NOTE: Date & initial all entries				QA: N/C Closed:	Date:

DART AEROSPACE LTD	Work Order:	24434
Description: Saddle, Aft Outboard	Part Number:	D2573
Inspection Dwg: D2573 Rev. D	1	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. D and record below:

			Re	corded Actu					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	Ву	Date
Α	0.438	0.443	DT8682	0.440	0.440	0,440	0.446		
В	1.745	1.755		10748		10748	1.748	-	
С	3.495	3.505		3-498	3.498	3.499	3.497		
D	1.745	1.755		1.750	1,748	1.750	1-746		
E	7.990	8.010		8.003	8.003	8004	8,004		
F	0.490	0.510		0.500	0 - 499	0.498	0.498		
G	0.257	0.262	DT8683	0.258	0.258	0-258	0.258		
H	0.375	0.380	DT8684	6.376	0.258	0.376	0.376		
1	0.490	0.510		0.502	6,499	0-498	0-499		
J	1.174	1.184		10177	1.176	1 177	1.177		
K	0.558	0.578		0-568	0-564	0.562	0-564		. #: ***
L	1.174	1.184		1.177	1-176	1.176	1 -177		
M	1.365	1.375		1 . 368	1 - 368	1.368	1.368		
N	2.495	2.505		2.497	2.497	1.368	2.496		
0	4.119	4.129		061.4	4,119	4.119	4-120		
Р	0.115	0.135		0.124		0,123	0-123		
Q	0.115	0.135		0-130	0-130	0.129	0.128		
R	0.240	0.260		0-245	0-246	0-246	0.247		
S	0.115	0.135		0-118	0-118	0,118	0-119		
T	0.178	0.198		0.188	0.188	0.188	9 -188		
U	3.210	3.250		3-231	3.231 0.2 <b>3</b> 4	3 - 231	3-231		
٧	0.230	0.250		0.233	0.234	0.233	0-234	<u> </u>	
W	0.115	0.135		0 -1 21	0-122	0.121	0-132		· y
Х	0.308	0.313		0-310	0.310	0 - 310	0,310		
Y	0.760	0.765		0-760		0.760	0-760		
Z	0.352	0.372		0-367	0.366	0,362	0-363		,
AA	0.470	0.530		0,500	0.500	0,500	0.500		
AB	0.615	0.635	7-7	0 -628	0.628	0.630	0.630		
AC	0.053	0.073		0.063	0-063	0.063	0.063		
AD	0.240	0.260		0.252	0.253	0-250	0-249		
AE	1.500	1.520		1.515	1 . 513	1.514	1-510		
AF	0.115	0.135	)	0.130	0 - 131	0.132	0.133		
AG	0.240	0.280		0.262	0.261	0.260	6.262	-	
AH	0.240	0.260		0.246	0.245	0.245	6.244		
Al	2.000	2.020		3.000	3 - 600 }	2,002	2.001		. 25.2
	Acc	ept/Reje	ct						

Measu	red by:	5.G.		
•	Date:	06/01	114	

 Audited by	Ep	
 Date:	06/6//17	,

Rev	Date	Change	Revised by	Approved
Α		New Issue	RF	
В	02.09.26	Re-format; Added Rev. D	KJ	<del> </del>
С	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05:05	Added dimension Al	KJ/RF	1-1



DART AEROSPACE LTD	- Work Order:	24434
Description: Saddle, Aft Outboard	Part Number:	D2573
Inspection Dwg: D2573 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. D and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	Ву	Date
Α	0.438	0.443	DT8682	0-440	0.440	0.440	0.440		
В	1.745	1.755		1.748	1.746	1.746	1.746		
С	3.495	3.505		3.497	3.496	3.496	3.496		
D	1.745	1.755		1.748	1.746	1.746	1:746		
E	7.990	8.010		8.004	8-004	8-004	8.004		
F	0.490	0.510		0.495	0.499	D1498	0.499		
G	0.257	0.262	DT8683	0-258	0-258	0.258	2-258		
Н	0.375	0.380	DT8684	0.376	0 -376	<b>e</b> .376	0-376		
ofl′	0.490	0.510		0.500	0-501	0.500	0~561		
J	1.174	1.184		1.176	1 . 176	1.176	1-176		
K	0.558	0.578		0.566	0-566	0-566	0 - 565		
L	1.174	1.184		1.175	1-175	1 476	1-176		
М	1.365	1.375		1.367	1.175	1.367	1.367		
N	2.495	2.505		2,497	2,497	2-496	2-497		
0	4.119	4.129		4.120	4,119	4-119	4.120		
Р	0.115	0.135		0-125	0,124	0-125	0.126		
α	0.115	0.135		0 . 135	0-133	0.133	0-135		
R	0.240	0.260		0-248	0.247	0. 246	0-247		
S	0.115	0.135		0.118	211-0	0.117	0-118		
T	0.178	0.198		0 = 188	0-188	0.188	0 -100		
U	3.210	3.250		3.231	8.230	3.231	3-236		
V	0.230	0.250		0.233	0-234	0.235	0-233		
W	0.115	0.135		0-123	0.123	0.124	0.125		1.0
X	0.308	0.313		0.310	0-311	0-311	0-311		
Υ	0.760	0.765		0-760	0.760	0.760	0.760		
Z	0.352	0.372		0.364	0.362	0.361	0.360		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.623	0.625	0-698	0.632		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.280	0-249	0.248	0 -248		
AE	1.500	1.520		1.516	1 ,515	1 = 515	1.516		
AF	0.115	0.135		0-132	0.133	0-134	0-132		
AG	0.240	0.280		0.265	0-264	0-260	0.261		
AH	0.240	0.260		0-242	0.242	0.243	0.242		
Al	2.000	2.020		2.003	2-003	2-002	2.001		
	Acc	ept/Reje	ct						

Measured by:	5.6	Audited by	ح	
Date: 0	6101116	Date:	oblotte	

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
В	02.09.26	Re-format; Added Rev. D	KJ	
С	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	1 .
D	05.05.05	Added dimension Al	KJ/RF	1



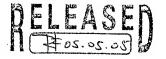
DART AEROSPACE LTD	Work Order:	24434
Description: Saddle, Aft Inboard	Part Number:	D2574
Inspection Dwg: D2574 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. D and record below:

Reco				corded Actu	ıal Dimensi				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	Ву	Date
Α	0.438	0.443	DT8682	0.440	0-440	0_440	0-440		
В	1.745	1.755		1.748	1,748	1.747	10748		
C	3.495	3.505		3.498	3-496	3.446	3.497		
D	1.745	1.755		1.750	1.748	1.748	10.746		
E	7.990	8.010		8,004	8,004	8,004	8.004		
F	0.490	0.510		0,497	0.448	0,497	0.447		
G	0.257	0.262	DT8683	0-258	0-258	0-258	0-258		
Н	0.375	0.380	DT8684	0_376	0-376	0-376	0-376		*****
1	0.490	0.510	- 2	0.499	0.498	0.500	0,498		
J	1.174	1.184		1 0176	1.176	1.176	1-177		
K	0.558	0.578		0-569			0.567		
L	1.174	1.184		1.176	1-176	1-176	1.176		
M	1.365	1.375	-	1.368	1.367	<b>4</b> - 368	1.367		
N	2.495	2.505		2.496	2-496	2.496	2 496		
0	4.119	4.129		4.120	4.)19	4.119	4.120		
Р	0.115	0.135	.,	0 - 123	0.123	0.127	0.127		
Q	0.115	0.135		0-132	0.133	0-131	0.133		1,000
R	0.240	0.260		0,246	0.245	0-247	0,248		7. 7. 7.
S	0.115	0.135		0-124	0-123	0.125	0-124		4-9
T	0.178	0.198		00188	0.188	0-188	0 188		
, U	3.210	3.250		3-232	3-23)	3.231	0.188		
V	0.230	0.250		0-235	0.234	0-237	0 - 236		
W	0.115	0.135		0-125	0.124	0.124	0.195		
X	0.307	0.312	***	0-311	0.311	0.311	0.310		
Υ	0.760	0.765		0.760	0 - 760	0-760	0.760		
Z	0.352	0.372		0-356	0.357	0-359	0.355		
AA	0.470	0.530		0.500	0 500	0.500	0.500		
AB	0.615	0.635		0-684	0-624	0.625	0.624		
AC	0.053	0.073		0-063	0 - 063	0-063	0.063		
AD	0.240	0.260		876.0	0.247	0-250			
AE	1.500	1.520		1.512	1.515		1.510		
AF	0.115	0.135		0-130	0-131	0-132	0_133		
AG	0.240	0.280		0-262	0.261	0.263	0. 265		
AH	0.240	0.260		0,246	0-245	0-263	0.243		
ΑI	2.000	2.020		NIA	N/A	NIA	NIA		
	Acc	ept/Reje	ct				***********		

Measured by: 13.6	Audited by
	riddied by Cas
Date:   06/01/15	Date: 56/6// 17
	5dic.   86/8// / T

Rev	Date	Change	Revised by	Approved
Α		New Issue	RF	
В	02.09.27	Re-format; Added Rev. D	KJ	
С	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension Al	KJ/RF	1



DART AEROSPACE LTD	Work Order:	24434
Description: Saddle, Aft Inboard	Part Number:	D2574
Inspection Dwg: D2574 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. D and record below:

Dim   Min   Max   Go/No Go   Gauge   1   2   3   4   By   Date	Recorded Actual Dimensions									
B 1.745 1.755 1.746 1.747 1.746 1.746 0.746 C 3.495 3.505 3.596 3.596 3.597 3.596 3.596 3.596 3.597 3.596 3.596 3.596 3.597 3.596 3	Dim	Min	Max	i		2	3	4	Ву	Date
C 3.495 3.505 3.946 3.497 3.497 3.497 3.496 D 1.745 1.755 1.7746 1.7747 1.747 8.790 8.010 9.004 8.003 8.005 0.50	Α			DT8682	0.440	0-440	0-440	0-446		
C 3.495 3.505 3.496 3.497 3.497 3.496 D 1.745 1.755 1.746 1.746 1.747 1.747 D 1.747 D 1.747 D 1.747 D 1.745 1.755 D 1.746 1.746 1.777 1.747 D 1.748 D					1.746	1747	1.746	1.746		
E 7.990 8.010 8.004 8.003 8.005 0.055 F 0.490 0.510 8.004 8.004 8.005 0.50 0.501 8.005 0.257 0.262 DT8683 6.258 0.	С				3-496	3.497	3-497	3-496		
F 0.490 0.510					11-176			1.747		
F 0.490 0.510					8,004	8.004	8.003	8.005		
H 0.375 0.380 DT8684 0.376 0.376 0.376 0.376 I 0.490 0.510 0.490 0.501 0.490 0.501 0.501 0.501 J 1.174 1.184 1.176 0.176 0.506 0.566 L 1.174 1.184 1.76 0.567 0.566 0.566 L 1.174 1.184 1.76 1.176 1.176 1.177 1.77 M 1.365 1.375 1.368 1.367 1.368 1.367 N 2.495 2.505 0.497 0.496 0.497 0.497 0.497 0.497 O 4.119 4.129 4.119 4.100 4.100 4.100 4.100 P 0.115 0.135 0.103 0.104 0.103 0.103 0.103 Q 0.115 0.135 0.103 0.104 0.103 0.103 R 0.240 0.260 0.244 0.247 0.247 0.245 S 0.115 0.135 0.103 0.104 0.103 0.103 T 0.178 0.198 0.108 0.108 0.108 0.108 0.108 U 3.210 3.250 3.200 3.231 3.230 23.231 V 0.230 0.250 0.250 0.335 0.234 0.232 W 0.115 0.135 0.104 0.105 0.103 0.104 0.103 0.103 X 0.307 0.312 0.311 0.311 0.311 0.311 Y 0.760 0.765 0.765 0.760 0.760 0.760 0.760 0.760 AA 0.470 0.530 0.302 0.360 0.360 0.360 0.360 0.357 AA 0.470 0.530 0.73 0.060 0.500 0.	F	0.490			0-499	0-498	0-300	0-501		
H 0.375 0.380 DT8684 0.376 0.376 0.376 0.376 I 0.490 0.510 0.490 0.501 0.490 0.501 0.501 0.501 J 1.174 1.184 1.176 0.176 0.506 0.566 L 1.174 1.184 1.76 0.567 0.566 0.566 L 1.174 1.184 1.76 1.176 1.176 1.177 1.77 M 1.365 1.375 1.368 1.367 1.368 1.367 N 2.495 2.505 0.497 0.496 0.497 0.497 0.497 0.497 O 4.119 4.129 4.119 4.100 4.100 4.100 4.100 P 0.115 0.135 0.103 0.104 0.103 0.103 0.103 Q 0.115 0.135 0.103 0.104 0.103 0.103 R 0.240 0.260 0.244 0.247 0.247 0.245 S 0.115 0.135 0.103 0.104 0.103 0.103 T 0.178 0.198 0.108 0.108 0.108 0.108 0.108 U 3.210 3.250 3.200 3.231 3.230 23.231 V 0.230 0.250 0.250 0.335 0.234 0.232 W 0.115 0.135 0.104 0.105 0.103 0.104 0.103 0.103 X 0.307 0.312 0.311 0.311 0.311 0.311 Y 0.760 0.765 0.765 0.760 0.760 0.760 0.760 0.760 AA 0.470 0.530 0.302 0.360 0.360 0.360 0.360 0.357 AA 0.470 0.530 0.73 0.060 0.500 0.	G	0.257	0.262	DT8683	6-258	0-258	0.254	0.258		
1	Н	0.375	0.380	DT8684	0.376	0.376	0.376	0.376		
N	ı	0.490	0.510		0-490	0-499	0 -501	0-501		
K 0.558 0.578	J		1.184			D 176	0-177			
L 1.174 1.184	K	0.558	0.578			0.567	0.566	0-566		1,
M 1.365 1.375 N 2.495 2.505 D - 197 D . 196 D . 197 D . 196 O 4.119 4.129 P 0.115 0.135 O . 197 0 . 194 0 . 193 0 . 193 O 0.115 0.135 O . 197 0 . 194 0 . 297 0 . 295 S 0.115 0.135 O . 194 0 . 297 0 . 198 O	· L	1.174	1.184			1,176	1.176	1 1 2 2	-	
N 2.495 2.505	М		1.375		1.368	1.367		1,367		
O 4.119 4.129	N		2.505			2,496				
P 0.115 0.135 0 .193 0 .194 0 -193 0 .193 Q 0.115 0.135 0 .197 0 .198 0 .197 0 .198 Q 0.197 0 .198 Q 0.198 Q 0.191 0 .198 Q 0.193 Q 0.	0	4.119								
Q 0.115 0.135 0.197 0.198 0.)37 0.198 R 0.240 0.260 0.344 0.344 0.344 0.345 0.193 0.										
R 0.240 0.260	Q						0.127	0 128		
S 0.115 0.135 0.198 0.19					0.244	0.244	0-247	0.245		
T 0.178 0.198 0.18	S		0.135		0-124	0-123	0-122	0.123		
U 3.210 3.250 3.230 3.231 3.230 €3.231 V 0.230 0.250 0.235 0.234 0.233 0.232 W 0.115 0.135 0.137 0.135 0.137 0.311 0.311 0.311 V 0.760 0.765 0.760 0.760 0.760 0.760 0.760 0.760 0.760 0.760 0.357 0.352 0.372 0.369 0.369 0.368 0.354 0.357 0.357 0.440 0.530 0.500 0.500 0.500 0.500 0.500 0.500 0.450 0.450 0.470 0.530 0.635 0.624 0.626 0.626 0.627 0.63 0.063 0.073 0.063 0.0	Т		0.198	* · · · ·	0-188	0.198	0 - 188	0-188		
V       0.230       0.250       0.935       0.234       0.233       0.232         W       0.115       0.135       0.124       0.125       0.125       0.123       0.134         X       0.307       0.312       0.311       0.311       0.311       0.311         Y       0.760       0.765       0.760       0.760       0.760       0.760         Z       0.352       0.372       0.368       0.354       0.354       0.357         AA       0.470       0.530       0.500       0.500       0.500       0.500       0.500         AB       0.615       0.635       0.624       0.632       0.632       0.637       0.063         AC       0.053       0.073       0.063       0.063       0.063       0.063       0.063       0.063       0.063         AB       1.500       1.520       0.351       0.250       0.251       0.250       0.249       0.249       0.128       0.127       0.128         AF       0.115       0.135       0.129       0.249       0.269       0.269       0.247       0.247       0.249         AH       0.240       0.260       0.250       0.247	C	3.210	3.250		3.220	3 .231	3 230	£3.231		
W       0.115       0.135       0.134       0.135       0.135       0.135       0.135       0.136       0.137       0.131       0.311       0.	V				0-235	0-234	0.233	0 232		-
X       0.307       0.312       0.311       0.351       0.357       0.3	W					0.125	0-123			
Y       0.760       0.765       0.760       0.760       0.760       0.760         Z       0.352       0.372       0.360       0.368       0.359       0.357         AA       0.470       0.530       0.500       0.500       0.500       0.500         AB       0.615       0.635       0.634       0.632       0.632       0.632       0.632         AC       0.053       0.073       0.063       0.63       0.063       0.063       0.063         AD       0.240       0.260       0.351       0.351       0.350       0.349         AE       1.500       1.520       1.512       1.513       1.513       1.513         AF       0.115       0.135       0.139       0.137       0.138         AG       0.240       0.280       0.364       0.364       0.364         AH       0.240       0.260       0.347       0.347       0.349         AI       2.000       2.020       0.347       0.247       0.349	X				0-311	0.311	0 311	0.31		
Z       0.352       0.372       0.360       0.360       0.359       0.357         AA       0.470       0.530       0.500       0.500       0.500       0.500       0.500         AB       0.615       0.635       0.634       0.632       0.632       0.632       0.632         AC       0.053       0.073       0.063       0.63       0.063       0.063       0.063         AD       0.240       0.260       0.251       0.250       0.249         AE       1.500       1.520       0.151       1.512       1.513       1.513         AF       0.115       0.135       0.129       0.128       0.127       0.128         AG       0.240       0.280       0.269       0.247       0.247       0.247       0.249         AH       0.240       0.260       0.250       0.247       0.247       0.247       0.246         AI       2.000       2.020       0.061 </td <td>Υ</td> <td></td> <td></td> <td>,</td> <td>0-760</td> <td>0.760</td> <td>0.760</td> <td>0.760</td> <td></td> <td></td>	Υ			,	0-760	0.760	0.760	0.760		
AA 0.470 0.530 0.500 0.500 0.500 0.500 0.500 AB 0.615 0.635 0.634 0.638 0.638 0.637 0.063	Z			**************************************	0.360	0-368	0-359	0.357		
AB 0.615 0.635 0.634 0.638 0.637 0.063 0.0						0-500	0.500	6.500		,
AC 0.053 0.073 0.063 0.663 0.063 0.063 AD 0.240 0.260 0.353 0.351 0.350 0.349 AE 1.500 1.520 0.135 0.134 0.135 0.137 0.138 0.137 0.138 AG 0.240 0.280 0.364						0 -620	0.629	0.627		
AD 0.240 0.260 0.350 0.351 0.350 0.349  AE 1.500 1.520 0.355 0.351 0.353 1.513  AF 0.115 0.135 0.139 0.138 0.137 0.138  AG 0.240 0.280 0.364 0.364 0.364  AH 0.240 0.260 0.250 0.347 0.247 0.346  AI 2.000 2.020 0.061 3.001 2.002					0.063	0.063		0.063		
AG 0.240 0.280 0.364 0.364 0.364 0.240 0.240 0.260 0.250 0.347 0.247 0.346 0.364 0.3					0. 252	0.251	0-250	0.249		
AG 0.240 0.280 0.364 0.364 0.364 0.240 0.240 0.260 0.250 0.347 0.247 0.346 0.364 0.3					1.515	1 512	1 513	1-513		
AG 0.240 0.280 0.364 0.364 0.364 0.240 0.240 0.260 0.250 0.347 0.247 0.346 0.364 0.3					0-129	9.178		0 132		
AH 0.240 0.260 0.250 0.247 0.247 0.246  AI 2.000 2.020 0.00 2.00 2.00 2.00 2.00 1					6. 264	a . 2 63	0.264			
AI 2.000 2.020 0.001 2-001 2-002 2.001						0 247	0.247	0.346		
										****
,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,				ct	<u> </u>		Q - 00A	5,001		

Measured by: 4.6.	Audited by	En
Date: 06/01/16	Date:	66/01/17

Rev	Date	Change	Revised by	Approved
Α		New Issue	RF	
В	02.09.27	Re-format; Added Rev. D	KJ	
С	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension Al	KJ/RF	1



## Job Costing Report

Dart Aerospace Ltd. Hawkesbury

Oct 05, 2005 10:49 am

Work Order No : 0024434S

Project Name : D2574

Project For

Work Order Type : Main

Main WO Number

House Part Number: D2574

Description : Saddle, Aft, In

Manufactured : Yes

Amount Req'd:

Amount Done : 0
Start Date : 10-05-05

Est Finish Date : 11-10-05

Act Finish Date : Drawings Reqd : No

Ok for Approval :

Approval Rec'd :

Department Code:

Burden Flags : NNNNNNN

WO Status : Open

Invoice State : Not Invoiced

Invoice Date :

Invoice Number:

Invoice Amount : 0.00

Order Entry No :

OE Value : 0.00

Est Mark Up : 0.000% Actual Mark Up : 0.000%

\$0 Posted to Finished Goods

		Estimated	Actual	٧ar. %	Posted	To Post
=	===	========	========	=======	========	=======================================
Material Cost	:	0.00	0.00	0.00	0.00	0.00
Engineering Hours	:	0.00	0.00	0.00		
Engineering Cost	:	0.00	0.00	0.00	0.00	0.00
Production Hours	:	0.00	0.00	0.00		
Production Cost	:	0.00	0.00	0.00	0.00	0.00
Packaging Hours	:	0.00	0.00	0.00		
Packaging Cost	:	0.00	0.00	0.00	0.00	0.00
OverHead Hours	:	0.00	0.00	0.00		
OverHead Cost	:	0.00	0.00	0.00	0.00	0.00
CNC Hours	:	0.00	0.00	0.00		
CNC	:	0.00	0.00	0.00	0.00	0.00
Misc. Hours	:	0.00	0.00	0.00		
Misc.	:	0.00	0.00	0.00	0.00	0.00
		========	========	======		
Burden	:	0.00	0.00	0.00		
		========		======		
Total Cost	:	0.00	0.00	0.00		
Mark up	:	0.000	0.000			
Selling Cost	•	0.00	0.00			
berring cobe	•	0.00	0.00			

Estimated Actual Labour Hrs/Amount Done : 0.00 0.00 Profits/(Loss) 0.00 0.00

## Job Costing Report

Dart Aerospace Ltd. Hawkesbury

Oct 05, 2005

10:49 am

: 0024434 Work Order No

Project Name : D2573/74
Project For : WK545
Work Order Type : Main
Main WO Number :

Burden Flags : NNNNNNN WO Status : Open

Invoice State : Not Invoiced

House Part Number: D2573

Invoice Date :

Department Code:

Description : Saddle, Aft, Out

Invoice Number :

Invoice Amount: 0.00

Manufactured : Yes

Order Entry No :

OE Value : 0.00

Est Mark Up : 0.000% Actual Mark Up : 0.000%

Amount Req'd: 8
Amount Done: 0
Start Date: 10-05-05
Est Finish Date: 11-10-05
Act Finish Date: No Ok for Approval :

\$0 Posted to Finished Goods

Approval Rec'd :

		Estimated	Actual	Var. %	Posted	To Post
Material Cost	. = =	0.00	0.00	0.00	0.00	0.00
Engineering Hours	:	0.00	0.00	0.00	0.00	••••
Engineering Cost	:	0.00	0.00	0.00	0.00	0.00
Production Hours	:	0.00	0.00	0.00		
Production Cost	:	0.00	0.00	0.00	0.00	0.00
Packaging Hours	:	0.00	0.00	0.00		
Packaging Cost	:	0.00	0.00	0.00	0.00	0.00
OverHead Hours	:	0.00	0.00	0.00		•
OverHead Cost	:	0.00	0.00	0.00	0.00	0.00
CNC Hours	:	0.00	0.00	0.00		
CNC	:	0.00	0.00	0.00	0.00	0.00
Misc. Hours	:	0.00	0.00	0.00		
Misc.	:	0.00	0.00	0.00	0.00	0.00
		========	========	======		
Burden	:	0.00	0.00	0.00		
		========	========	======	•	
Total Cost	:	0.00	0.00	0.00		
Mark up	:	0.000	0.000			
Selling Cost	:	0.00	0.00			

		Estimated	Actual
Labour Hrs/Amount Done	:	0.00	0.00
Profits/(Loss)	:	0.00	0.00

Job Costing Report

Dart Aerospace Ltd.

Hawkesbury

Nov 08, 2005 12:09 pm

Work Order No : 0024434

Project Name : D2573/74
Project For : WK545
Work Order Type : Main

Main WO Number

House Part Number: D2573

Description : Saddle, Aft, Out

Manufactured : Yes

Amount Req'd: 8
Amount Done: 0

Start Date : 10-05-05

Est Finish Date : 11-10-05

Act Finish Date : Drawings Reqd : No

Ok for Approval : Approval Rec'd :

Department Code:

Burden Flags : NNNNNNN WO Status : Open

Invoice State : Not Invoiced

Invoice Date :

Invoice Number :

Invoice Amount: 0.00

Order Entry No :

OE Value : 0.00

Est Margin : 0.000% Actual Margin : 0.000%

\$0 Posted to Finished Goods

		Estimated	Actual	Var. %	Posted	To Post
=======================================	===	=======================================	========	=======================================	=========	==========
Material Cost	:	0.00	0.00	0.00	0.00	0.00
Engineering Hours	:	0.00	0.00	0.00		
Engineering Cost	:	0.00	0.00	0.00	0.00	0.00
Production Hours	:	0.00	0.00	0.00		
Production Cost	:	0.00	0.00	0.00	0.00	0.00
Packaging Hours	:	0.00	0.00	0.00		
Packaging Cost	:	0.00	0.00	0.00	0.00	0.00
OverHead Hours	:	0.00	0.00	0.00		
OverHead Cost	:	0.00	0.00	0.00	0.00	0.00
CNC Hours	:	0.00	0.00	0.00		
CNC	:	0.00	0.00	0.00	0.00	0.00
Misc. Hours	:	0.00	0.00	0.00		
Misc.	:	0.00	0.00	0.00	0.00	0.00
		=======================================	=======	======		
Burden	:	0.00	0.00	0.00		
		=======================================	=======	======		
Total Cost	:	0.00	0.00	0.00		
Margin	:	0.000	0.000			12
Selling Cost	:	0.00	0.00			2/12
					1.5	

Estimated Actu
Labour Hrs/Amount Done : 0.00 0.0

Profits/(Loss) : 0.00

Actual 0.00 0.00

: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Monday, 14/11/2005 3:41:21 PM

Alba Panzuto

## **Process Sheet**

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

: 24434 : 10533

**Estimate Number** This Issue

Prsht Rev.

First Issue

Written By

Previous Run

P.O. Number

: 14/11/2005

S.O. No. :

: NC : //

Type

: MACHINED PARTS

**Part Number** 

**Drawing Name** 

**Drawing Number** 

: D2573 : D2573 REV D

**Project Number** 

: D **Drawing Revision** 

Material **Due Date** 

: 30/11/2005

Qty:

8 Um:

Each

Checked & Approved By

Comment

: Est: H 02.10.02 Re-format; Change to Dwg Rev. D &

incorporated D2574KJ

**Additional Product** 

Job Number:



Seq. #:

2.0

Machine Or Operation:

**Description:** 

1.0 D6101007

HAAS1

7075-T7351 8.25X7.75X2.5 HAAS CNC VERTICAL MACHINING #1







Comment: HAAS CNC VERTICAL MACHINING #1

Program Batch No. \_\_Double check by:\_\_

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per

Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets

4-Deburr and remove all machining marks

5-Tumble to remove sharp edges.

3.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE







Comment: CONVENTIONAL MILLING MACHINE

Machine keyway as per dwg D2573 & D2574

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE





Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

Date:

Monday, 14/11/2005 3:41:21 PM

Alba Panzuto

**Process Sheet** 

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 24434

Part Number: D2573

Job Number:



Seq. #:

**Machine Or Operation:** 

Description:

6.0

HAND FINISHING

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

10.0

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion

